	er ID 58215 29, 2010 10:38:28 AM	# - - - - -									Page 1	
Item ID: Revision ID:	D3536-39			Accept					Setup S			
	Gasket 4/29/2010 Start Qty: 5/14/2010 Req'd Qty:				Cust l Custo	Item ID: mer:			S	itop		
Approvals:	Process Plan:		e: <u>104-29</u>	Tooling: SPC (Y/N):		_ Date:				C.		
Sequence ID/ Work Center II		a.		Set Up/ Run Hours	Drav Nun		raw Plan ev. Cod		Reject Qty		eject imber	Insp. Stamp
Draw Nbr	Revision Nbr					•						
D3536 100 Waterjet FLOW CNC Waterjet	et 1-0	R JET emo Cut as per Dwg D3 burr if necessary	. , 3536 □Dwg Rev	0.00 0.00 ∴ Prog Rev:	\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\	.: '2		R	10-S-	(()
QC Quality Control		arts off machine F	AI/FAIB	0.00				tg.	10 -5-	<u> </u>		
QC Quality Control		arts - second check	C	$J_{\omega} Z_{00.0}^{00.0}$	15/12			\ \ \ \\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\)		— Norman Adam	

Dart .	Aeros	pace	Ltd
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W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	PROCEDURE CHANGE					Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Part No	•	PAR #:	Fault Cate	gory:	NCF	R: Yes	No DQA	ı:	Date:				
Resolution:													
NCR:			WORK ORD	ER NON-CONFORM	IANCE	(NCR)			· · · · · · · · · · · · · · · · · · ·			
DATE	STEP	Description of NC	Corrective Action Section B			Verifica			Approval	Approval			
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C		Chief Eng	QC Inspector			
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Work Order ID 58215

Thursday, April 29, 2010 10:38:28 AM



Page 2

Item ID:

D3536-39

Accept

Setup Start

Stop

Stop



Revision ID:

Item Name: Gasket

Start Date: 4/29/2010 Required Date: 5/14/2010

Start Qty: 8.00 Req'd Qty: 8.00

Cust Item ID:

Customer:

Draw

Number

Reference: Approvals:

Process Plan: _____ Date: ____ Tooling:

Date:

Run Start



Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Memo

Memo

Set Up/ **Run Hours**

0.00

0.00

Draw Rev.

Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

0-2-19



140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

10/05/13 AS

Dart Aerospace I	Ltd
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W/O:		WORK ORDER CHANGES											
DATE	STEP	PR	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No	:	PAR #:	Fault Cate	gory:	NCI	R: Yes	No DQ	A:	Date:				
						QA: N/C Closed: Date:							
NCR:			WORK ORDI	ER NON-CONFORM	MANCE	(NCR)						
DATE	OTED	Describition of NC			ection B		Verific	ation	Ammental	A			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	1	Sign & Date	Secti		Approval Chief Eng	Approval QC Inspector			
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Picklist Print

Thursday, April 29, 2010 10:38:28 AM

Work Order ID: 58215

Parent Item: D3536-39

Parent Item Name: Gasket

Comments:

IPP Rev:A New Issue 07-02-14 JLM

Start Date: 4/29/2010

Start Qty: 8.00

Required Date: 5/14/2010

Required Qty: 8.00

Component Item ID/ Item Name

Replacement Mfg/ Item ID Purch

Purchased

Bin Primary Item Location

No

Last Location

Route Seq ID

100

Unit of Measure

sf

Qty on Hand

208.7531

Qty per Kit

0.7534

Date Issued

114176

Status

B10-5-11

Page 1

MNEO60S.063

NEOPRENE SHEET 0.063

Location

MAT052

114176

Loc Oty

208.7531 208.7531 Loc Code

114176

Qty

Issued



W/O:			WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE				/	Date Qt	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
												
D1 N-							·····					
			Fault Category: N									
Resolution:			Dispositio	1:	QA: N/	C Clos	sed:		Date: _			
NCR:			WORK ORDI	ER NON-CONFORM	IANCE (N	ICR)						
DATE	STEP	Description of NC	Corrective Action		ction B	tion B Sign &		ation	Approval	Approval		
		Section A	Initial Chief Eng	Action Description Chief Eng		gn & late	Section C		Chief Eng	QC Inspector		
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DART AEROSPACE LTD	Work Order:	58215
Description: Gasket	Part Number:	D3536-39
Inspection Dwg: D3536 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	X	Prototyp	е		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Metho
35.71	+/-0.030	35,71			ļ - -
32.78	+/-0.030	37.78	4		
20.28	. / 0 000	30116	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ 		<u> </u>

	Dimension	Tolerance	Dimension	Accept	Reject	Method of Inspection	Comments
. [35.71	+/-0.030	35,71				
	32.78	+/-0.030	35.78	18-			
	29.28	+/-0:030:	29.38	V			
. [25.78	+/-0.030	25.78	-			
	23.25	+/-0.030	23.76	4			
	19.75	+/-0.030	19.75	b 6			
	17.75	+/-0.030		4			<u> </u>
	14.25	+/-0.030	(7,78	-			
	9.50	+/-0.030	14.75	مد			
	4.75	+/-0.030	9.50 4.76	<u>K</u>			
	5.00	+/-0.030		×			
	9.00	+/-0.030	9,00	<u>></u>			
	0.30	+/-0.030		<u>۲</u>			
	0.30	+/-0.030	1 -	3			
	1.88	+/-0.030	1 100- 1				
	Ø0.19	+0.005/-0.001		7			
	0.063	+/-0.010	1 c = T	8			
			, 005	7			
							
				1	1		1

Measured by:	R	Audited by:	Prototype Approval:	N/A
Date:	10-5-11	Date: Wolfe	Date:	N/A .
Pay Data	Chama			

Ke	V	Date	Change		
Α		07.03.14		Revised by	Approx/ed
·				KJ/JLM	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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	.			•									
Part No	•	PAR #:	Fault Cate	gory:	NCI	R: Yes	No DQ	4 :	Date:				
Resolution:			Dispositio	n:	QA:	N/C Cid	osed:		Date:				
NCR:				ER NON-CONFORM									
DATE	STEP	Description of NC	Corrective Action Section B			Verif		ation	Approval	Approval			
	Section A		Initial Chief Eng	Action Description Chief Eng		Sign & Date		Section C Chief Eng		QC Inspector			
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07.02.12

06.10.25 CHECKED B **6** D3536 GASKET DRAWING NO. DART AEROSPACE PORT HADLOCK, ≸ USA, SHEET 5 OF 6 NC. REV. SCALE 1:10

30.75 27.25 2.00 4.75 1.89 6.00 16.00 DETAIL A 21.00 **#**0.19 D3536-37 GASKET (TYP 4 PLS)



2.00	9.00 ———————————————————————————————————
	D3536-39 GASKET

1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEOBO-S 2) FINISH: NONE

3) PART IS SYMMETRICAL ABOUT Q
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT
PERMANENT INK MARKER
7) SEE PAGE 6 FOR DETAILS AND SECTION

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W/O:			WORK ORDER CHANGES								
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A :	_ Date: _			
	Re	esolution:	Dispositio	n:	_ QA: N/C C	losed:		Date: _			
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NCI	7)					
DATE	STEP	Description of NC	1	Corrective Action Section		Verifi	cation	Approval	Approval		
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign o		ion C	Chief Eng	QC Inspector		
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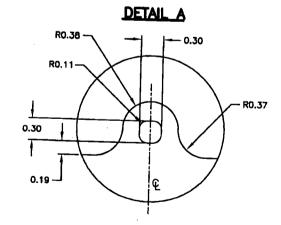
07.62.12

27.98 25.08 #58215 2.00 -1.88 4.00 #0.19 (TYP 2 PLS) 3.90 DETAIL

D3536-41 GASKET

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60
 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- DUROMETER (REF DARI SPEC. M-NEUDU-S
 2) FINISH: NONE
 3) PART IS SYMMETRICAL ABOUT Q
 4) TOLERANCES ARE PER DART QSI 018 UNLESS
 OTHERWISE NOTED
 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT
 PERMANENT INK MARKER



C B	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED //	DRAWING NO.
 77	#	D3536 SHEET 6 OF 6
DATE		TILE 3-1111
06.10.25		GASKET

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W/O:	WORK ORDER CHANGE									• •
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	,									
			19.11.2							
Part No		PAR #:								
	Re	esolution:	Dispositi	on:	QA: I	V/C Clo	sed:		_ Date: _	
NCR:		•	WORK ORE	DER NON-CONFORM	ANCE	(NCR		A A A A A A A A A A A A A A A A A A A		
DATE	STEP	Description of NC			tion B	<u> </u>	Verific	ation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section	on C	Chief Eng	QC Inspector
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